

# Work Order ID 83340

April-17-12 2:16:21 PM

ASAP

\*83340\*

Page 1

Item ID: D3564-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearshoe

Start Date: 17/04/2012 Start Qty: 16.00

\*16\*

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 16.00

\*16\*

Customer:

Reference:

Approvals: Process Plan: MCT

Date: 12/04/17

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\* Dwg Rev: D Prog

Rev: D 2-Deburr if necessary

B 12-418

16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

1812-4-18

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

Scraping

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83340

April-17-12 2:16:21 PM

**\*83340\***

Page 2

Item ID: D3564-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Wearshoe  
Start Date: 17/04/2012 Start Qty: 16.00 **\*16\*** Cust Item ID:  
Required Date: 24/04/2012 Req'd Qty: 16.00 **\*16\*** Customer:  
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157	0.00  0.00				16	0		SA 12/04/12
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Ensure joggle as per dwg D3429	0.00  0.00		5126419		(16)			
150 <b>*150*</b> Large Fab Large Fab	Large Fab  Memo Qty Description Batch A/R 2059B Hardcoat Weld hardcoat as per Dwg D3437	0.00  0.00				(16)	ME/EL.	12-04-25	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*83340\***

Page 3

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Item ID: D3564-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Wearshoe

Stop **\*NS2\***

Start Date: 17/04/2012 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

**\*180\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200F

800

M117338

(16)

16X

M-L

12/4/26

W/O:		WORK ORDER CHANGES					
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**\*83340\***

Page 4

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Revision ID:

Item Name: Wearshoe

Stop **\*NS2\***

Start Date: 17/04/2012 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00

**\*190\***

QC

Memo

0.00

Quality Control

16 0 12-4-26

200

Identify as per dwg & Stock Location 4P-1

0.00

**\*200\***

Packaging

Memo

0.00

Packaging

16 0 12-4-26

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

12/4/26

12-04-26

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# Picklist Print

April-17-12 2:16:25 PM

Page 1

Work Order ID: 83340

\*83340\*

Parent Item: D3564-3

\*D3564-3\*

Parent Item Name: Wearshoe

Start Date: 17/04/2012

Required Date: 24/04/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-03-08 ec  
IPP Rev:B As per Rev C 07-07-09 JLM  
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	231.6520	1.1	18.52632			

\*M304S16GA\*

304/316 Sheet .063

\*\*

B 12-4-17

Location

Loc Qty

Loc Code

MAT020

231.652

120866

38.446

120877

137.326

121070

55.88

121070

(16)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

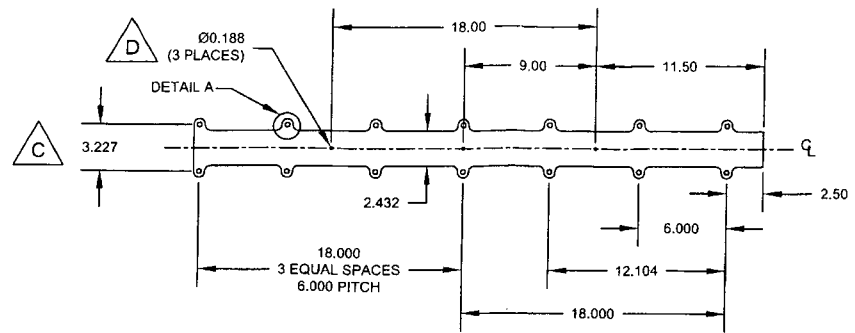
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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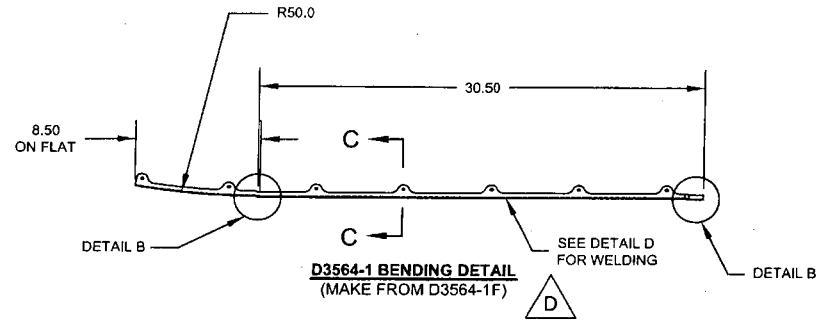
**NOTE:** Date & initial all entries

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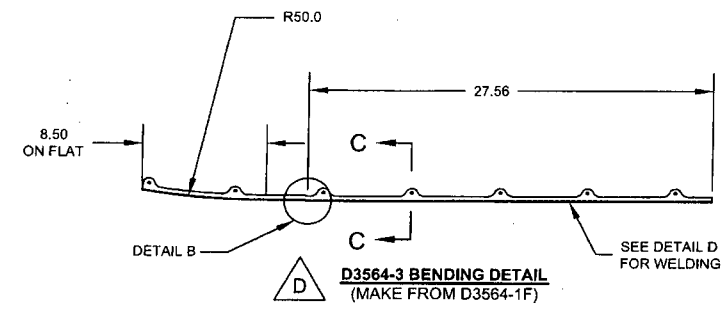


**D3564-1F FLAT PATTERN**

**RELEASED**  
07.09.04



**D3564-1 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)

**UNDER REVIEW**  
11/02/17  
Twist change  
OK 11/11/18

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83348 MLC  
12/04/17

- D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
  - 2) FINISH: POWDER COAT GREY SANDEXT (REF 4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: SEE TABLE IN ZONE A3
  - 8) WELD PER DART QSI 004
  - 9) SEE PG 3 FOR SECTIONS AND DETAILS
  - 10) PARTS ARE SYMMETRIC ABOUT C

**WEIGHTS:**

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3564	REV. D SHEET 1 OF 3
TITLE WEARSHOE	SCALE 1:8
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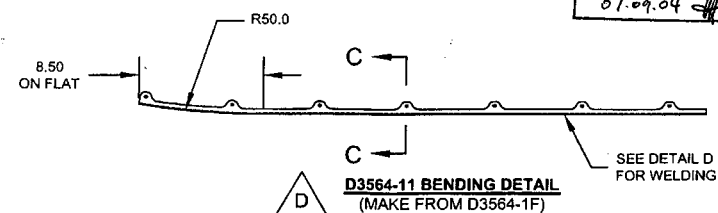
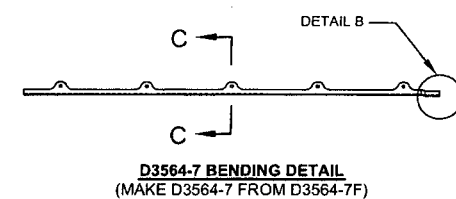
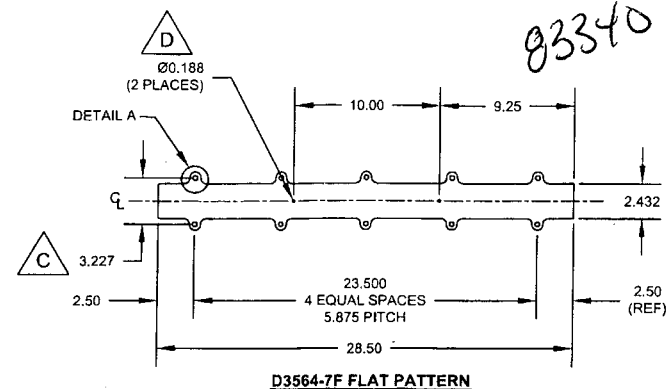
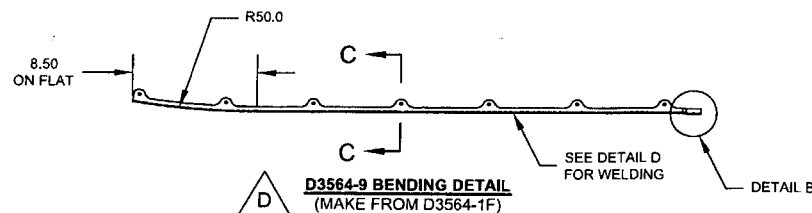
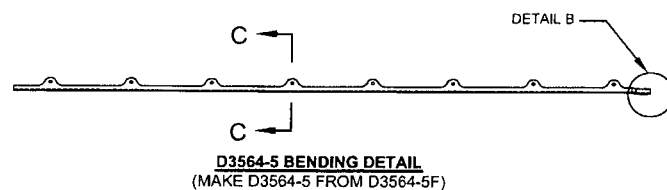
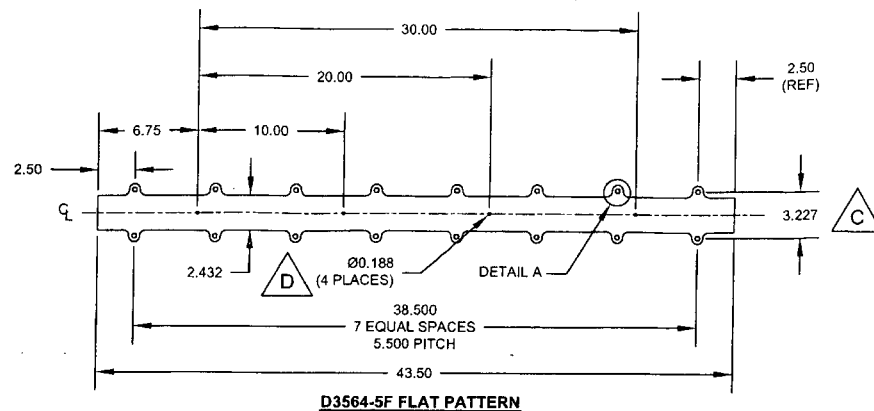
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UNDER REVIEW  
OK 07.11.28

RELEASED  
07.09.04

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SH	D3564	SHEET 2 OF 3
APPROVED	ND	TITLE	SCALE
DE APPR.	SH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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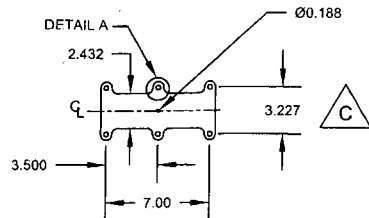
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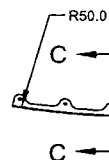
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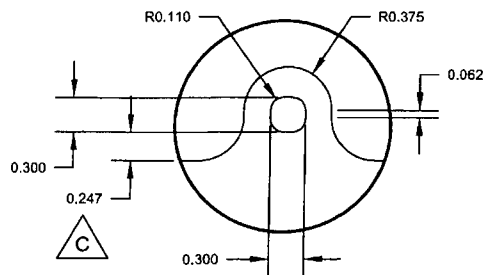




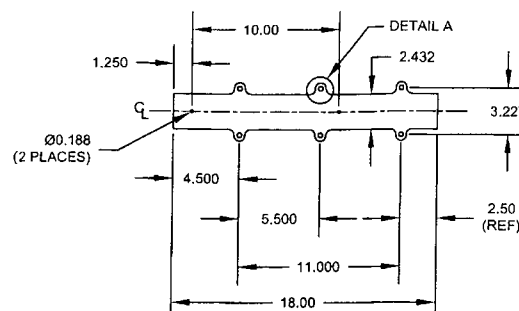
**D3564-13F FLAT PATTERN**



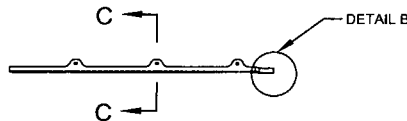
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



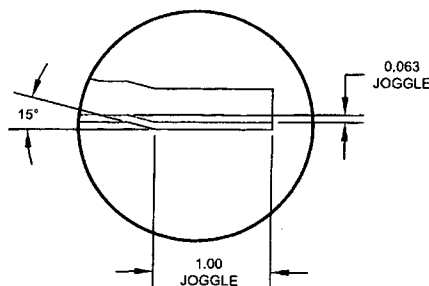
**DETAIL A**  
SCALE 1:1



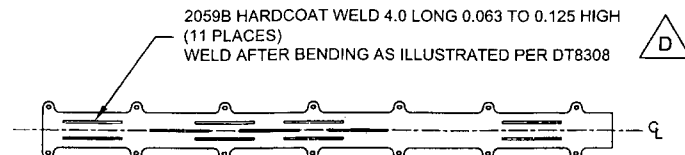
**D3564-15F FLAT PATTERN**



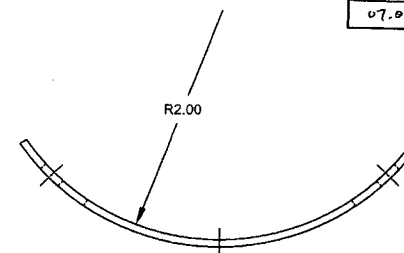
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



**DETAIL B**  
SCALE 1:1



**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



**SECTION C-C**  
SCALE 1:1

**RELEASED**

07.09.04

**UNDER REVIEW**  
OK 07.11.28

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DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
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